Dart Aerospace Ltd.

Date: Monday, 22/10/2007 2:17:19 PM
User: Linda Lacelle

Process Sheet

K. Split

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: ARM
Job Number	: 35297 -R2		
Estimate Number	: 12883		
P.O. Number	:	**Part Number**	: D3560043
This Issue	: 22/10/2007 **S.O. No.** :	**Drawing Number**	: D3560 ~~UNDER REVIEW~~
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : SMALL /MED FAB	**Drawing Revision**	: C
Previous Run	: 35031	**Material**	:
Written By	:	**Due Date**	: 29/10/2007 **Qty:** ~~14~~ 2 **Um:** Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 07.05.24 EC		
	Est Rev B ECN 987 07.10.09 EC		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X05000	6061-T6 Bar .50" x 5.0"

Comment: Qty.: 1.3598 f(s)/Unit Total : 19.0365 f(s)
6061-T6 Bar 0.50" x 5.00"
Batch: M10,182 NK 07/11/30 (14)

2.0	BAND SAW	BAND SAW

Comment: BAND SAW
Cut blanks 15.500" long NK 07/11/30 (14)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA695 Rev: AA & Dwg D3560 Rev: C

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560 SF 07/12/07

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE SF 07/12/07

5.0	QC8	SECOND CHECK

Comment: SECOND CHECK 07 12 11 (14)

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Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	D35921	PLATE

Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)
PLATE
B35331 B35331 08.08.14 SP 2X. 08-07-10 - SP (4X)

7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:
1- clean material (buff bracket and bottom of arm with blue pad) SP SP
2- set up bracket and arm on jig SP SP
3- preheat bracket and arm with torch SP SP
4- clean before welding with brush SP SP
5- set up machine to 135 amps SP SP
6- weld across bottom and top ends SP SP
7- reheat with torch ( ) SP SP
8- on one side weld from bottom to top half way SP
9- same for other side (half way) SP SP
10- from half way point weld the rest of the first side (ease off pedal near end) SP 08.08.14 (2X.)
11- same for remaining side (ease off pedal near end) SP 08-07-10 SP (4X.)

8.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP
08.08.15 (2)

9.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION
08.08.14 08-08-14 (2)

10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1
SP 08.08.15 (2X)

11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION
08.08.15 2

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Job Number: 35297 **Part Number:** D3560043

Job Number:

Seq. #:	Machine Or Operation:	Description :
12.0	D2808	Spacer

Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)
Spacer
batch: B3713 SB 08/08/18 (2)

13.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Press bushing in D3560 arm per dwg D3562 SB 08/08/18 (2)

14.0	QC5	INSPECT WORK TO CURRENT STEP

08-08-18 (2)

Comment: INSPECT WORK TO CURRENT STEP

15.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: WIP 08.08.18 2

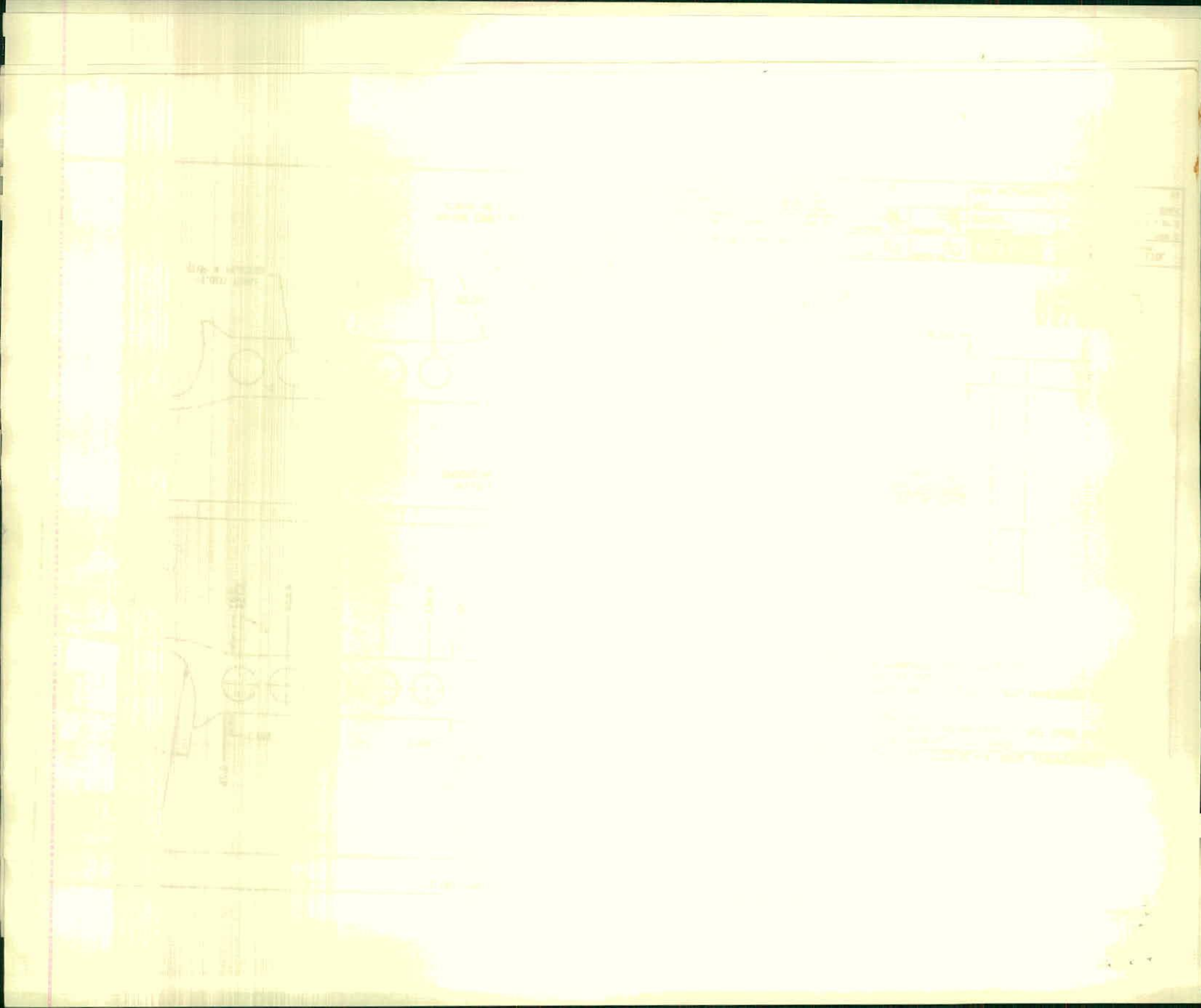
16.0	QC21	FINAL INSPECTION/W/O RELEASE

08/08/18 (2)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion MF 08.08.18

Form: rprocess



DART AEROSPACE LTD	Work Order:	3547
Description: Arm	Part Number:	D3560-3
Inspection Dwg: D3560 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	5065	✓			
Ø0.196	+0.005/-0.001	.196	✓			
Ø1.000	+0.010/-0.001	1.000	✓			
Ø0.900	+0.010/-0.001	.899	✓			
0.500	+/-0.010	.502	✓			
0.250	+/-0.010	.250	✓			
0.275	+/-0.010	.276	✓			
0.188	+/-0.010	.199	✓			
2.000	+/-0.010	2.002	✓			
1.750	+/-0.010	1.752	✓			
1.702	+/-0.010	1.704	✓			
Ø0.385 x 100°	+/-0.010 x 0.5°	.391	✓			
0.250 Deep	+/-0.010	.250	✓			

Measured by:	SP	Audited by:	JL	Prototype Approval:	N/A
Date:	07/12/07	Date:	07/12/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	